

Date: Friday, 11/17/2006 9:07:58 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	29512					
Estimate Number	10533					
P.O. Number	N/A					
This Issue	11/17/2006	S.O. No. : N/A	Part Number	: D2573		
Prsht Rev.	NC				Drawing Number : D2573 REV E	
First Issue	N/A	Type : MACHINED PARTS	Project Number	: N/A		
Previous Run	29161				Drawing Revision	: E
Written By					Material	: N/A
Checked & Approved By					Due Date	: 12/5/2006
Comment	Est: 1	As Per RevE 06-01-27 JLM	Qty:	16	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	7075-T7351 8.25X7.75X2.5	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: <u>325353</u> x 16	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>SD</u> Double check by: <u>SG</u> 06/12/03	
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/12/17
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/17/2006 9:07:59 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 29512

Part Number: D2573

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Ex 061215 x 16

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m

06/12/18

X16

7.0 POWDER COATING POWDER COATING



M102391

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-a/fc

06/12/18 (16)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/12/18 (16)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STY78

06/12/18 (16)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



(16)

Comment: FINAL INSPECTION/W/O RELEASE

06/12/18

Job Completion



C Loc 112119

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order: 29512	
Description: Saddle, Aft Outboard				Part Number: D2573	
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.435	0.439	0.440	0.440		
B	1.745	1.755		1.750	1.749	1.750	1.750		
C	3.495	3.505		3.500	3.499	3.500	3.500		
D	1.745	1.755		1.750	1.749	1.750	1.750		
E	7.990	8.010		8.002	7.997	8.000	8.000		
F	0.490	0.510		0.500	0.499	0.504	0.502		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.377	0.376	0.376		
I	0.490	0.510		0.510	0.501	0.502	0.502		
J	1.174	1.184		1.179	1.178	1.178	1.179		
K	0.558	0.578		0.578	0.567	0.566	0.569		
L	1.174	1.184		1.179	1.178	1.178	1.179		
M	1.365	1.375		1.370	1.368	1.369	1.369		
N	2.495	2.505		2.500	2.500	2.500	2.499		
O	4.119	4.129		4.124	4.121	4.121	4.121		
P	0.115	0.135		0.126	0.127	0.127	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.252	0.251	0.252		
S	0.115	0.135		0.130	0.130	0.131	0.129		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.242	0.240	0.240	0.240		
W	0.115	0.135		0.124	0.131	0.132	0.126		
X	0.308	0.313		0.311	0.316	0.311	0.311		
Y	0.760	0.765		0.760	0.766	0.760	0.760		
Z	0.352	0.372		0.365	0.364	0.364	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.630	0.631	0.630		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.251	0.247	0.245	0.246		
AE	1.500	1.520		1.511	1.503	1.513	1.512		
AF	0.115	0.135		0.135	0.125	0.125	0.125		
AG	0.240	0.280		0.260	0.265	0.267	0.262		
AH	0.240	0.260		0.251	0.250	0.249	0.249		
AI	2.000	2.020		2.000	2.002	2.003	2.003		
AJ	0.023	0.043		0.030	0.031	0.030	0.030		

Accept/Reject

Measured by:	SD 19ml	Audited by:	SD
Date:	06/12/06	Date:	06/12/06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SD

DART AEROSPACE LTD			Work Order:	29512
Description: Saddle, Aft Outboard			Part Number:	D2573
Inspection Dwg: D2573 Rev. E			Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.000		
F	0.490	0.510		.500	.498	.500	.496		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.376	.376	.376	.376		
I	0.490	0.510		.500	.503	.501	.503		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.567	.567	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.129	4.124	4.124	4.124		
P	0.115	0.135		.126	.126	.127	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.127	.126	.128	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.130	.131	.131	.131		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.763	.763	.763	.763		
Z	0.352	0.372		.362	.361	.363	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.631	.630	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.249	.248		
AE	1.500	1.520		1.513	1.513	1.513	1.513		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.279	.278	.278	.278		
AI	2.000	2.020		2.002	2.003	2.003	2.002		
AJ	0.023	0.043		.030	.030	.030	.030		
Accept/Reject									

Measured by:	grd / SD	Audited by:	Er
Date:	06.12.07	Date:	06/12/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SD

DART AEROSPACE LTD				Work Order: 29512	
Description: Saddle, Aft Outboard				Part Number: D2573	
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	.440	.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.001	7.999	8.000		
F	0.490	0.510		.500	.495	0.502	0.502		
G	0.257	0.262	DT8683	.258	.258	0.258	0.258		
H	0.375	0.380	DT8684	.376	.376	0.377	0.377		
I	0.490	0.510		.503	.501	0.502	0.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	0.567	0.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.122	4.126		
P	0.115	0.135		.126	.127	0.127	0.126		
Q	0.115	0.135		.133	.135	.135	0.135		
R	0.240	0.260		.250	.257	0.251	0.251		
S	0.115	0.135		.129	.125	0.130	0.130		
T	0.178	0.198		.188	.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.240	.270	0.241	0.241		
W	0.115	0.135		.127	.129	0.132	0.131		
X	0.308	0.313		.311	.311	0.311	0.310		
Y	0.760	0.765		.763	.767	0.761	0.761		
Z	0.352	0.372		.364	.364	0.365	0.365		
AA	0.470	0.530		.500	.500	0.500	0.500		
AB	0.615	0.635		.626	.627	0.628	0.632		
AC	0.053	0.073		.063	.063	0.063	0.063		
AD	0.240	0.260		.248	.249	0.247	0.246		
AE	1.500	1.520		1.513	1.515	1.512	1.512		
AF	0.115	0.135		.133	.135	0.126	0.125		
AG	0.240	0.280		.260	.260	0.260	0.260		
AH	0.240	0.260		.248	.248	0.250	0.251		
AI	2.000	2.020		2.002	2.007	2.002	2.005		
AJ	0.023	0.043		.030	.030	0.030	0.030		
Accept/Reject									

Measured by:	SD	Amf	Audited by:	EP
Date:	06/12/08	06/12/11	Date:	06/12/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SD

DART AEROSPACE LTD				Work Order:	29512
Description: Saddle, Aft Outboard				Part Number:	D2573
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.439	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.502	0.502	0.502	0.502		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.502	0.502	0.501	0.500		
J	1.174	1.184		1.179	1.179	1.178	1.178		
K	0.558	0.578		0.568	0.568	0.568	0.567		
L	1.174	1.184		1.179	1.179	1.178	1.178		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.121	4.121	4.121	4.121		
P	0.115	0.135		0.127	0.127	0.127	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.251	0.251	0.251		
S	0.115	0.135		0.129	0.130	0.129	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.236	3.230		
V	0.230	0.250		0.240	0.240	0.241	0.241		
W	0.115	0.135		0.132	0.131	0.133	0.133		
X	0.308	0.313		0.310	0.310	0.311	0.311		
Y	0.760	0.765		0.761	0.761	0.761	0.761		
Z	0.352	0.372		0.365	0.364	0.364	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.632	0.630	0.630	0.630		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.247	0.247	0.248	0.247		
AE	1.500	1.520		1.512	1.513	1.512	1.511		
AF	0.115	0.135		0.125	0.125	0.125	0.125		
AG	0.240	0.280		0.268	0.270	0.265	0.268		
AH	0.240	0.260		0.250	0.249	0.250	0.250		
AI	2.000	2.020		2.002	2.002	2.001	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	<i>ml</i>	Audited by:	<i>EP</i>
Date:	06/12/11	Date:	06/12/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>kg</i>	<i>gall</i>

